

Date: Tuesday, 5/23/2006 8:36:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 27204B
 Estimate Number : 10339
 P.O. Number : N/A
 This Issue : 5/23/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 26802
 Part Number : D2658
 Drawing Number : D2658 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : N/A
 Due Date : 6/10/2006 Qty: 30 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.05.23
 Comment : Est Rev: A New Issue 05-11-07 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1312

Laser cut per Drawing Flat pattern D2658

Material release note required

C200105124

(30)

2.0 D2658F Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
 Lug Bracket

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

AL 06/06/01 (30)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2658T1

06.06.01 30

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr as required.

2-Bend on CNC brake using DT8254 Identify as D2658

MF 06-06-01

HM 06/06/02

SB 06/07/02

(30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: LS Date: 06/08/01
 QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27204B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-07-20

(30)

Comment: INSPECT WORK TO CURRENT STEP

7.0

DC

DOCUMENT CONTROL



(30)

Comment: DOCUMENT CONTROL

Inspection Level 21

06-08-01

Job Completion



06.08.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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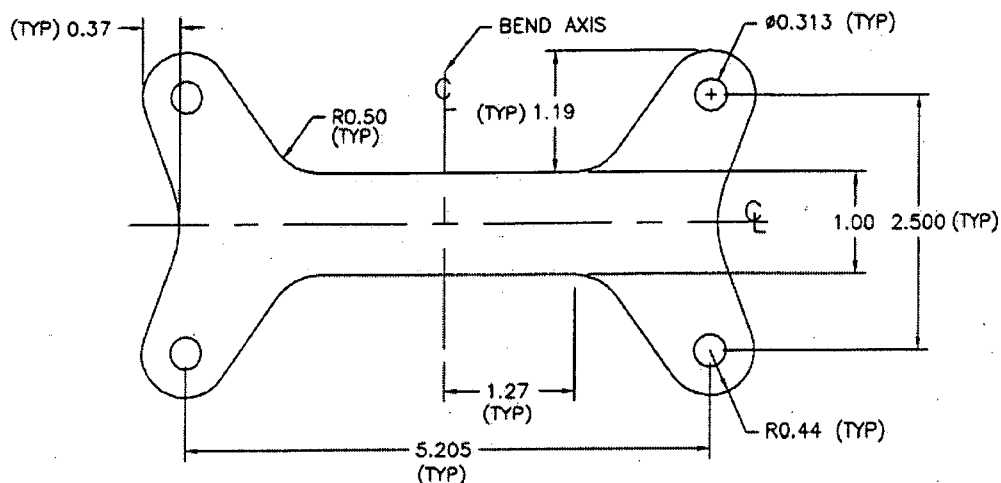
NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

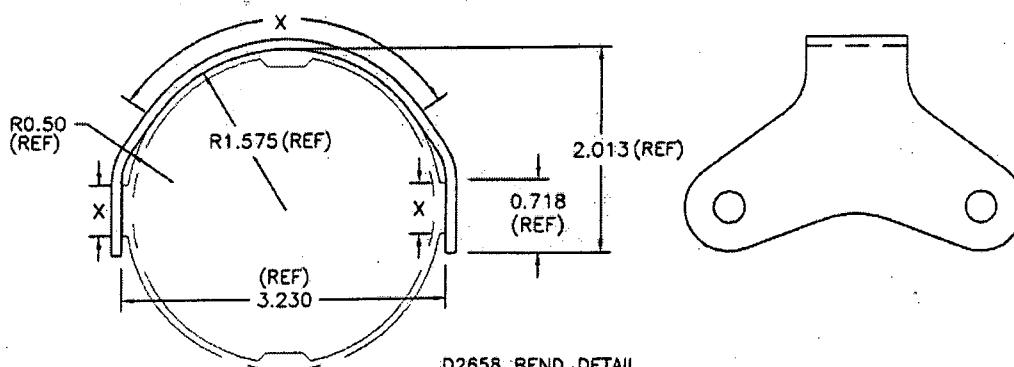


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

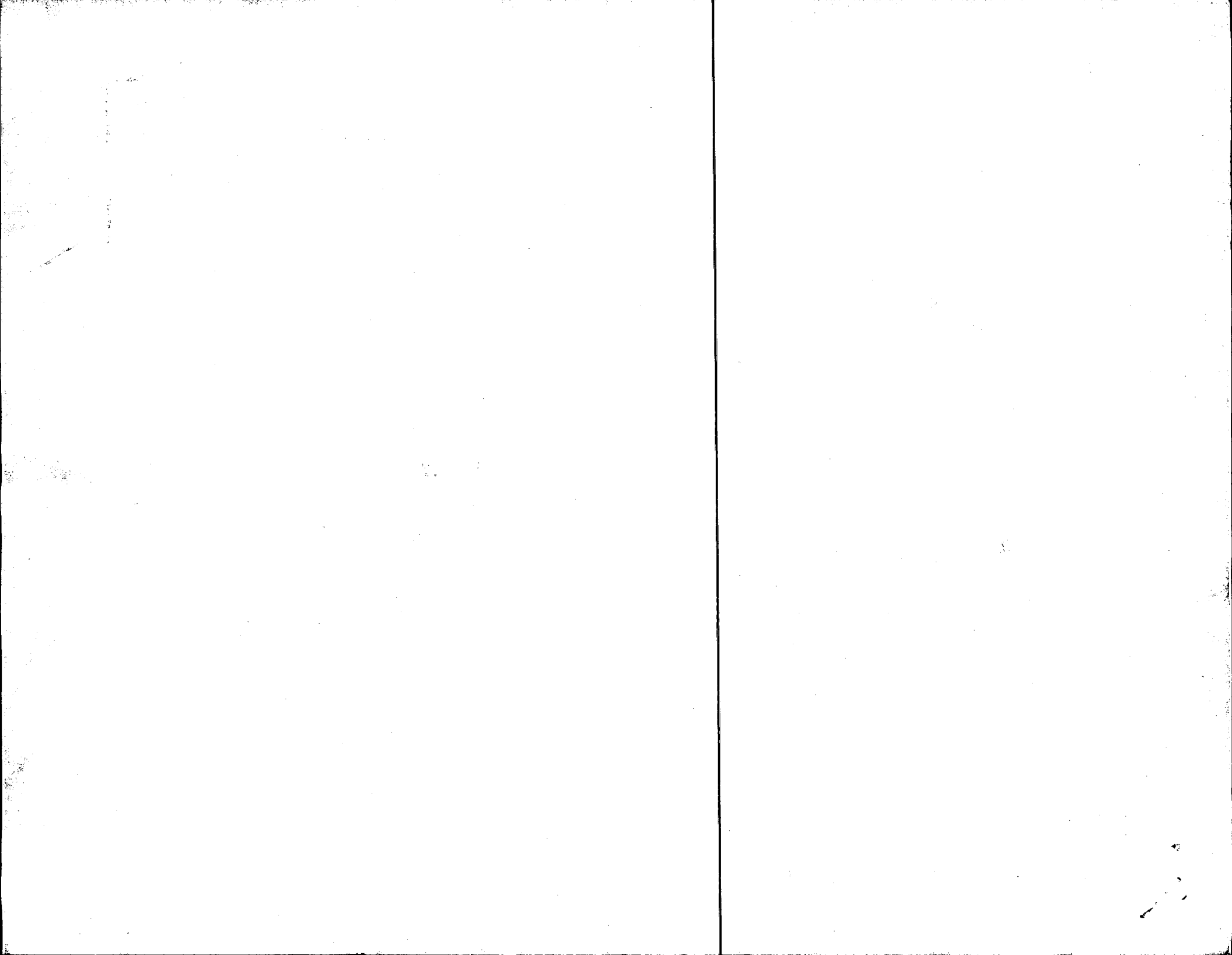
D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 272 D4B



California Steel Industries
14000 San Bernardino Ave.
Fontana, California 92335
Ph (909) 350-6300

CERTIFIED TEST REPORT

PO: 227168
MAN: 551013 MDC

8

CUSTOMER ORDER P50614ME002		MO. NUMBER 02-8344-01	SHIPPING DATE 08/01/05	CAR NUMBER RR: WCTR142061	TALLY NUMBER PO 250499136 1/
B I L T O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR., VANCOUVER BC, CANADA, V5X2V3		S H I P T O	WILKINSON STEEL-METALS C/O GARY R. HAMILTON TRUCKING 888 S.E. MARINE DR., VANCOUVER BC, CANADA BC V5Y 2	

MARK ALL DOCUMENTS W/P.O. P50614ME002. FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX #604-301-3244.

END USE	WAREHOUSE STOCK - NON-CRITICAL SURFACE
PROD	H.R. COILS - P & O - PRIME
SPEC	ASTM-A-1011-00-CS-TYPE B

T/R	1	INSPECTION	MILL
DESCRIPTION		COILS, PIECES OR BUNDLES	HEAT NUMBER
.0605 x 48.0000 x COIL NOM ME		1 1	T42354 T42348
<p>I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.</p> <p><i>Arthur D. Jenkins</i></p> <p>CHIEF - LABORATORY SERVICES</p>			

MECHANICAL PROPERTIES							CHEMICAL ANALYSIS														10:48:05		08/01/05		CC	
HEAT OR LOT NUMBER	SLAB NUMBER	LOC	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION		BEND TEST	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Cb	Ti	N					
					1"	2"																				
T42354								08	.39	010	006	006	01	01	01	00	050	000	000	000	002					
T42348								08	.38	014	010	007	01	01	01	00	046	000	000	001	003					

CTR-001 PTLUC221 990712



New Zealand Steel Limited
 Christchurch, South Auckland
 Postal Private Bag 92121, Auckland New Zealand
 Telephone: (09) 375 8999 / 375 8111 Auckland
 (09) 235 8009 / 235 3535 Wairakei
 Fax: (09) 375 8999

TEST CERTIFICATE

Ref: SM325703

CUSTOMER		Wilkinson		SPECIFICATION		ASTM A1008 Type B		CERTIFICATE No		TC124640														
CUSTOMER ORN		98-31N-108		PRODUCT		HOT-ROLLED-PICKLED & OILED		PAGE		1 of 1														
MILL ORN		518691		DIMENSIONS		0.104" x 48" x Coil		DATE		17 January 2006														
		CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION)												
PACK NUMBER	(Sample) HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CEI	BEND	YIELD	T.S.	ELONG	HARDNESS	LENGTH	
		x100										x10000		x100	180°									
HP-997711-00	646664	6	1	20	9	19												Good					942	
HP-997712-00	646664	6	1	20	9	19												Good					961	
HP-997713-00	646846	5	TR	20	11	19												Good					955	
HP-997714-00	646846	5	TR	20	11	19												Good					955	
HP-997715-00	646664	6	1	20	9	19												Good					955	
HP-997716-00	646664	6	1	20	9	19												Good					958	
HP-997717-00	646846	5	TR	20	11	19												Good					958	
HP-997718-00	646846	5	TR	20	11	19												Good					958	
HP-997719-00	646846	5	TR	20	11	19												Good					958	
HP-997720-00	646846	5	TR	20	11	19												Good					958	
HP-997721-00	646846	5	TR	20	11	19												Good					958	
HP-997722-00	646846	5	TR	20	11	19												Good					958	

YIELD	GAUGE LENGTH (GL)		PLASTIC STRAIN RATIO (R)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=50mm	(A)=0	(A)=10mm x 10mm	(A)=C+Mn/6
(D)=LOWER YIELD STRESS	(B)=50mm	(D)=565 ± 50	(B)=100	(B)=7.5mm x 10mm	(B)=C+Mn/6+(C+V+Mo/5)+(Cu+Ni/15)
		(E)=2"	(C)=145	(C)=5mm x 5mm	(C)=C+Mn/6+5/24
		(F)=8"	(D)=50+(50+245)/4	(D)=2.5mm x 10mm	(D)=
				(E)=5mm x 10mm	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
 QC MGR IN CHARGE

SM325703-2 T M INDUSTRIAL 951122ME001.646846

